



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3296-041
Job Sheet 176202



Part No: D3296-041

Job Qty: 4 ea

Part Name: Replacement Interior Door For -111



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/18/18

Job Tracking No:

Due Date: 5/15/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP C 05.10.14 Added step 14 KJ/EC IPP Rev:D Revised Steps 06-11-20 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	4 Ea		5/14/18	0.00	0.00	Start Up Small Fab-2		MAY 14 2018
100	Small Fab	4 pcs		5/14/18	0.00	1.61	Small Fab-3		DAS
110	QC	4 pcs		5/14/18	0.00	0.00	QC5		33
120	Powdercoat	4 pcs		5/14/18	0.00	0.31	Powdercoat4		BRN 3-16
130	QC	4 pcs		5/14/18	0.00	0.00	QC3		MAY 16 2018
140	Small Fab	4 pcs		5/15/18	0.00	1.61	Small Fab-3		DAS
150	QC	4 pcs		5/15/18	0.00	0.00	QC5		9
160	Packaging	4 pcs		5/15/18	0.00	0.00	Packaging3-1	ST 436	MAY 18 2018
170	QC21-SA	4 Ea		5/15/18	0.00	0.00	QC21		MAY 18 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3161-7	Hinge 14.0"	4 Ea (1 ea)	90-Start up Operation	S057683
D3161-9	Hinge 17.0"	4 Ea (1 ea)	90-Start up Operation	S056932
D3296-1	Door Panel	4 Ea (1 ea)	90-Start up Operation	S048285
D3296-3	Door Panel	4 Ea (1 ea)	90-Start up Operation	S057683
MS20470AD4-6	Rivet, Universal Head	4 Ea (1 ea)	90-Start up Operation	S041165
D2137	Decal(No Step)	4 Ea (1 ea)	140-Small Fab	S046301
D2419	Handle	4 Ea (1 ea)	140-Small Fab	S066968
D2462	Neoprene Seal (\$Per Foot)	11.2664 ft (2.8166 ea)	140-Small Fab	F1158.32
D2728-1	Dart Logo Label Small	4 Ea (1 ea)	140-Small Fab	
MS20470AD4-4	Rivet, Universal Head	100 Ea (25 ea)	140-Small Fab	Fm130878
NAS1149DN632J	Washer	4 pcs (1 ea)	140-Small Fab	S057683

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3161-7	4	4	0
	D3161-9	4	4	0
	D3296-1	4	10	0
	D3296-3	4	8	0
	MS20470AD4-6	4	4,234	0
140-Small Fab	D2137	4	22	0
	D2419	4	1	0
	D2462	11	233	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Supervisor ification		
			Coordinator val		
			Wrong mensions er tolerance rect Missing ed		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		
			☐ Misaligned/off center ☐ Turning Sequence		
			OTHER :		

Part: D3296-041
 Job No: 176202
 Serial No/Batch: S070987
 Revision:
 Inspector:



Container No: S070987
 DART AEROSPACE
 1270 Aberdeen Street
 Hecksburg, ON K5A 1K7
 CANADA
 TEL: 1 813 832-5200
 Email: sales@dartaero.com
 www.dartaero.com

Date: 05/14/18

D2728-1	4	0	0
MS20470AD4-4	100	3,569	0
NAS1149DN632J	4	386	0

Part Specifications

Specifications could not be found.

Plex 4/18/18 1:18 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				